

Work Order ID 83912

83912

Page 1

April-27-12 11:18:59 AM

Item ID: D3825-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly (Basket End)

Start Date: 27/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Process Plan: MJS

Date: 12/04/27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3825	Rev A
-------	-------

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825
A/R S.S. Rod Batch: M121602

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

SAD 12-05-23 (6)

SB/CC 12-6-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83912

83912

Page 2

April-27-12 11:18:59 AM

Item ID: D3825-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly (Basket End)
 Start Date: 27/04/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		P (12.06.04)		6X	Ø		
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				6			W 12.06.04
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo BASKET CELL	0.00 0.00				6	Ø		Ae 12.06.06

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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April-27-12 11:18:59 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/04/2012 **Start Qty:** 2.00

~

Cust Item ID:

Required Date: 11/05/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

12/6/11 

MF
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April-27-12 11:19:03 AM

Page 1

Work Order ID: 83912

83912

Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	17.0000	1	2			

D2327-3

Spacer Bushing

**

/cc 12-5-30

Location

Loc Qty

Loc Code

WA
82706
WA005
75564
77229
81144

13
13
4
1
1
2

B83757 →
B82325 →

(5)

(0)

D3759-1

Manufactured No

D3759-1

Bushing

100

Each

341.0000

1

2

**

/cc 12-5-30

Location

Loc Qty

Loc Code

WA
79213
WA005
66489
82785

135
135
206
1
205

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-27-12 11:19:03 AM

Page 2

Work Order ID: 83912

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

83912

D3825-041

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

M304TS0.750W.065

Purchased

No

100

f

1,013.792

2.125

~~4.473684~~ 13.424

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

~~SAD~~ 12-05-23

CPL

1.9831672

~~13.424~~ 4.78049

0.5907428

6.0667

Location

Loc Qty

Loc Code

MAT017

553.7325342

120267

53.7325342

120633

500

MAT018

453.40289

121170

412.40289

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

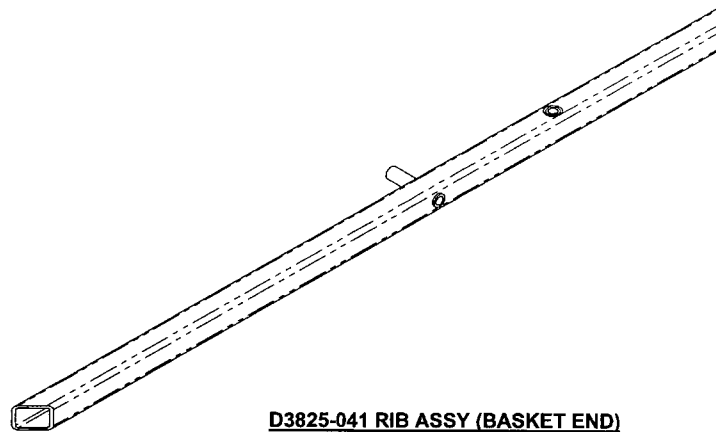
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83912 MLJ
12/04/27

RELEASED
08/11/23

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A		NEW ISSUE		MB	08.09.23
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.	D3825	REV. A	SHEET 1 OF 3
MFG. APPR.		TITLE	RIB ASSY (BASKET END)	SCALE	NTS
APPROVED		DATE 08.09.23			
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

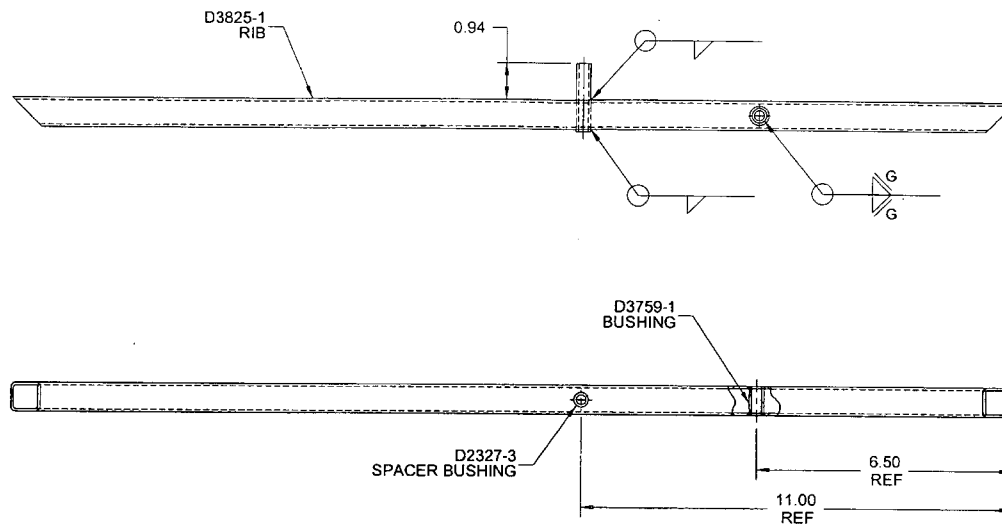
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

83912



D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO.	REV. A
MFG. APPR.	MS	D3825	SHEET 2 OF 3
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	RIB ASSY (BASKET END)	NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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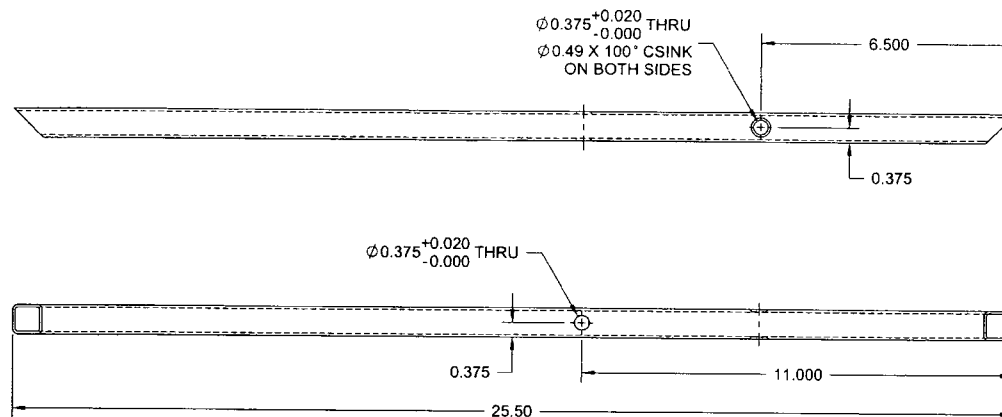
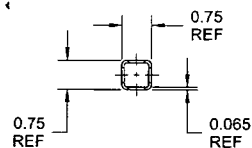
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D3825-1 RIB

RELEASED
08/11/13

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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